



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3884-2
Job Sheet 168901



Part No: D3884-2

Job Qty: 4 ea

Part Name: Saddle, Inside RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/24/17

Job Tracking No:

Due Date: 12/15/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by: EC IPP REV: B 15.05.20 remove inside powdercoat DD
VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/14/17	12/14/17	0.00	0.00	Start Up Machining		FK 17-12-21
100	CNC Vertical Machining	4 pcs	12/14/17	12/14/17	0.31	7.02	HAAS 1		FK 17-12-21
110	QC	4 pcs	12/14/17	12/14/17	0.00	0.00	QC2		FK 17-12-22
120	QC	4 pcs	12/14/17	12/14/17	0.00	0.00	QC8		FK 17-12-22
130	HandFinish	4 pcs	12/14/17	12/14/17	0.00	0.37	HandFinish1		2017-12-22 JS
140	Powdercoat	4 pcs	12/15/17	12/15/17	0.00	0.21	Powdercoat1		FK 17-12-27
150	QC	4 pcs	12/15/17	12/15/17	0.00	0.00	QC3		DEC 27 2017
160	Packaging	4 pcs	12/15/17	12/15/17	0.00	0.00	Packaging3		
170	QC21-SA	4 Ea	12/15/17	12/15/17	0.00	0.00	QC21		

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets
Descriptions: 2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA819
and inspect per Dimension Sheets
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)***

M 138467. START: 7:50 O.D.T. 320° FINISH: 8:10

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-017	4	1	0	0

Part Specifications

Specifications could not be found.

Plex 11/24/17 11:07 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube Machining Thermoforming Large Fab
Part No. _____		
NCR No. _____		
Date : _____	Step #: _____	QTY Effect _____

Description Work Order Deviation

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cur ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/ ☐ Inspection Incom ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
OTHER : _____			

PART NO:
Revision:
Operation:
Change No:

D3884-2
Start up Operation

Mfg Date: 12/21/17
 Job No: 168901

Saddle, Inside RH



S025889



Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Fit/Function ☐

Misaligned/off center ☐

Turning Sequence ☐

DART AEROSPACE LTD		Work Order:	168901
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.645	.647	.646	.645		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		.153	.152	.152	.152		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		.125	.125	.125	.125		
M	0.240	0.260		.250	.250	.250	.250		
N	0.110	0.140		.135	.135	.135	.135		
O	0.240	0.260		.253	.253	.252	.252		
P	2.826	2.886		2.857	2.857	2.857	2.857		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.153	.153	.152	.150		
S	0.720	0.780		.765	.765	.765	.765		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.501	.501	.500	.500		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.313	.313	.313	.313		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.001	1.001	1.000	1.001		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by:	FK-
Date:	17-12-22

Audited by:	mmc
Date:	17/12/22

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	